

Date: Friday, 11/18/2005 3:18:16 PM  
 User: Linda Lucelle

## Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 24839 -	Part Number	: D2573
Estimate Number	: 10533	Drawing Number	: D2573 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 12/20/2005
Previous Run	: 24434	Qty:	8 (12) Um: Each
Written By	: See comment below		
Checked & Approved By	: See comment below		
Comment	: Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2573  
 Ensure that grain is along 7.75" length  
 Batch No: B24893

J.G / M8

06/01/09

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. B24899 Double check by: En 06/01/09

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per -J.G M8 06/01/09  
 Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets -J.G M8 06/01/09  
 4-Deburr and remove all machining marks -J.G M8 06/01/09  
 5-Tumble to remove sharp edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2573 & D2574

J.G / M8

06/01/09

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DP Date: 06/01/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 11/18/2005 3:18:16 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 24839

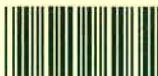
Part Number: D2573

Job Number:



Seq. #: Machine Or Operation: Description :

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.6 06/01/14

8

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

EP 06/01/14

8

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/01/14

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7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML 06 01 16

8

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

6 06/1/17 8

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 377

PO 06/1/17 (8)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/18 (8)

SP 06/01/18 (8)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No	: 0024839	Department Code:	
Project Name	: D2573	Burden Flags	: NNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2573	Invoice Number	:
Description	: Saddle, Aft, Out	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 12	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 12-20-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573	
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	✓	✓	✓	✓	
B	1.745	1.755		1.746	1.751	1.752	1.751		
C	3.495	3.505		3.495	3.502	3.501	3.501		
D	1.745	1.755		1.746	1.750	1.752	1.751		
E	7.990	8.010		8.002	8.003	8.008	8.003		
F	0.490	0.510		0.500	0.507	0.503	0.508		
G	0.257	0.262	DT8683	0.257	✓	✓	✓	✓	
H	0.375	0.380	DT8684	0.376	✓	✓	✓	✓	
I	0.490	0.510		0.498	0.507	0.503	0.498		
J	1.174	1.184		1.179	1.178	1.180	1.180		
K	0.558	0.578		0.564	0.578	0.565	0.566		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.371	1.370	1.370	1.370		
N	2.495	2.505		2.501	2.500	2.500	2.500		
O	4.119	4.129		4.127	4.125	4.121	4.122		
P	0.115	0.135		0.131	0.130	0.126	0.127		
Q	0.115	0.135		0.120	0.128	0.133	0.135		
R	0.240	0.260		0.255	0.255	0.248	0.252		
S	0.115	0.135		0.134	0.135	0.128	0.124		
T	0.178	0.198		0.187	0.188	0.188	0.188		
U	3.210	3.250		3.233	3.233	3.232	3.233		
V	0.230	0.250		0.247	0.246	0.242	0.242		
W	0.115	0.135		0.116	0.135	0.133	0.130		
X	0.308	0.313		0.308	0.308	0.308	0.308		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.365	0.368	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.635	0.631	0.633	0.635		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.256	0.260	0.258	0.249		
AE	1.500	1.520		1.506	1.506	1.508	1.511		
AF	0.115	0.135		0.118	0.128	0.125	0.130		
AG	0.240	0.280		0.255	0.270	0.270	0.255		
AH	0.240	0.260		0.257	0.256	0.255	0.255		
AI	2.000	2.020		2.000					
AJ	0.023	0.043							
Accept/Reject									

Measured by: <u>S.G.</u>	Audited by: <u>EP</u>
Date: <u>06/01/05</u>	Date: <u>06/01/14</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED  
05/12/05

THE UNIVERSITY OF CHICAGO PRESS

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573	
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.748	1.748	1.748	1.747		
C	3.495	3.505		3.499	3.497	3.497	3.498		
D	1.745	1.755		1.748	1.747	1.748	1.747		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.504	0.505	0.503	0.504		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.502	0.500	0.499	0.501		
J	1.174	1.184		1.177	1.178	1.178	1.176		
K	0.558	0.578		0.569	0.568	0.567	0.565		
L	1.174	1.184		1.178	1.177	1.178	1.177		
M	1.365	1.375		1.368	1.368	1.368	1.367		
N	2.495	2.505		2.495	2.496	2.497	2.498		
O	4.119	4.129		4.119	4.120	4.121	4.121		
P	0.115	0.135		0.123	0.124	0.123	0.123		
Q	0.115	0.135		0.135	0.134	0.135	0.133		
R	0.240	0.260		0.249	0.248	0.247	0.247		
S	0.115	0.135		0.122	0.122	0.120	0.123		
T	0.178	0.198		0.190	0.190	0.190	0.190		
U	3.210	3.250		3.230	3.230	3.231	3.231		
V	0.230	0.250		0.239	0.240	0.238	0.238		
W	0.115	0.135		0.127	0.126	0.127	0.123		
X	0.308	0.313		0.308	0.308	0.308	0.308		
Y	0.760	0.765		0.362	0.362	0.362	0.362		
Z	0.352	0.372		0.365	0.364	0.363	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.634	0.635	0.635	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.252	0.251	0.253		
AE	1.500	1.520		1.510	1.509	1.510	1.512		
AF	0.115	0.135		0.127	0.130	0.129	0.130		
AG	0.240	0.280		0.265	0.264	0.262	0.261		
AH	0.240	0.260		0.251	0.249	0.249	0.247		
AI	2.000	2.020		2.001	2.001	2.000	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <u>S.G.</u>	Audited by: <u>En</u>
Date:	Date: <u>06/01/14</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

**RELEASED**  
05/12/09



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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1	

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D	1.745	1.755		1.751	1.751	1.750			
E	7.990	8.010		7.990	8.002	8.002			
F	0.490	0.510		.510	.510	.503			
G	0.257	0.262	DT8683	✓	✓	✓			
H	0.375	0.380	DT8684	✓	✓	✓			
I	0.490	0.510		.506	.503	.500			
J	1.174	1.184		1.180	1.180	1.180			
K	0.558	0.578		.573	.569	.570			
L	1.174	1.184		1.180	1.180	1.180			
M	1.365	1.375		1.371	1.371	1.371			
N	2.495	2.505		2.500	2.500	2.500			
O	4.119	4.129		4.123	4.123	4.123			
P	0.115	0.135		.122	.125	.124			
Q	0.115	0.135		.135	.135	.135			
R	0.240	0.260		.245	.249	.244			
S	0.115	0.135		.126	.124	.126			
T	0.178	0.198		.188	.188	.188			
U	3.210	3.250		3.232	3.232	3.230			
V	0.230	0.250		.237	.240	.236			
W	0.115	0.135		.125	.125	.125			
X	0.308	0.313		.312	.312	.312			
Y	0.760	0.765		.762	.762	.762			
Z	0.352	0.372		.362	.367	.368			
AA	0.470	0.530		.500	.500	.500			
AB	0.615	0.635		.633	.629	.629			
AC	0.053	0.073		.063	.063	.063			
AD	0.240	0.260		.249	.252	.249			
AE	1.500	1.520		1.512	1.512	1.510			
AF	0.115	0.135		.133	.120	.135			
AG	0.240	0.280		.260	.258	.255			
AH	0.240	0.260		.249	.248	.243			
AI	2.000	2.020		2.008	2.010	2.010			
AJ	0.023	0.043		.03	.03	.03			
Accept/Reject									

Measured by:	MS
Date:	06/01/13

Audited by:	EP
Date:	06/01/14

Rev	Date	Change	Revised by	Approved
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**RELEASED**  
05/12/09



